

Date: Monday, 17/11/2008 10:58:44 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FILLER
Job Number : 43414	
Estimate Number : 11145	
P.O. Number :	Part Number : D320811
This Issue : 17/11/2008 S.O. No. :	Drawing Number : D3208 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A1
Previous Run : 43414	Material :
Written By :	Due Date : 28/11/2008 Qty: 10 Um: Each
Checked & Approved By : <u>JULIE DAWSON</u>	
Comment : Est: A04.06.09 New issue KJ/RF est B 08.11.17 Waterjet EC verified: DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
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Comment: Qty.: 0.1728 sf(s)/Unit Total : 1.7283 sf(s)
 Material: 2024-T3 (QQ-A-250/4) 0.040" thick aluminum sheet
 (M2024T3S.040)

Batch: 107461 HB 8-12-9

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3208
 Dwg Rev: A1
 Prog Rev: A1

HB 8-12-9

2-Deburr if necessary

08/12/16 (13)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

08/12/17 (13)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

08/12/17 (13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 17/11/2008 10:58:44 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FILLER

Job Number: 43414

Part Number: D320811

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



13X

Comment: INSPECT CHEMICAL CONVERSION COAT

M- 08/12/17

7.0

PACKAGING 1

PACKAGING RESOURCE #1



13X

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 77

8/12/17

SP

8.0

QC21

FINAL INSPECTION/W/O RELEASE



08/12/18

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MK 08-12-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

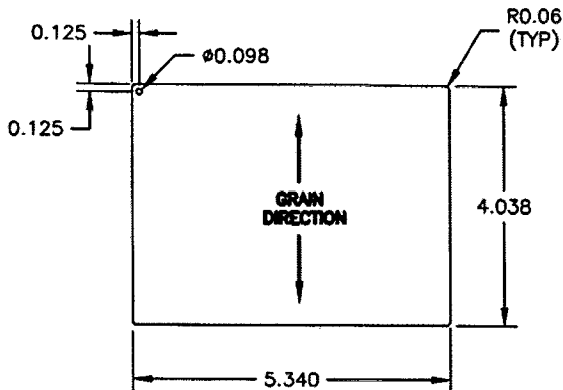
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

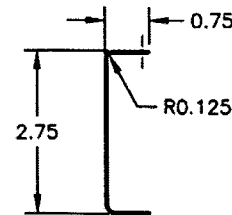
DART

DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3208	REV. A SHEET 1 OF 3
DATE 04.01.27		TITLE DOUBLER	SCALE 1:3
A	04.01.27	NEW ISSUE	
AI	# 04.05.25	CHANGE DIM; NOTE 3) CHANGE	

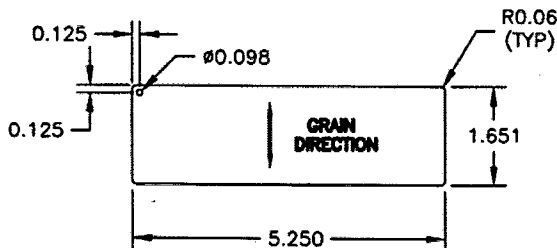
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04.04.05



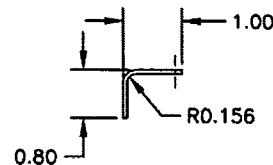
2 D3208-1 DOUBLER
FLAT PATTERN



D3208-1 DOUBLER
BEND DETAIL



3 D3208-3 PEDAL MOUNT ANGLE
FLAT PATTERN



D3208-3 PEDAL MOUNT ANGLE
BEND DETAIL

NOTES:

- 1) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040" THICK (M2024T3S.040)
- 3) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063" THICK (M2024T3S.063)
- 4) MATERIAL: 2024-T3 (QQ-A-250/4) 0.080" THICK (M2024T3S.080)
- 5) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES
- 3) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063" THICK (M6061T6S.063)

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WORK ORDER

NO. 43414

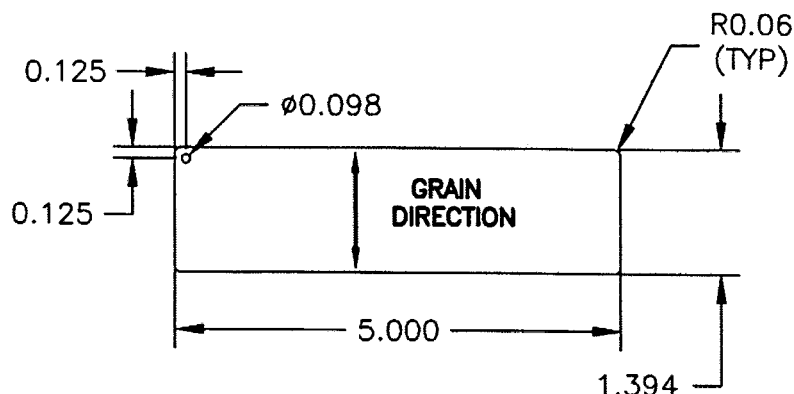
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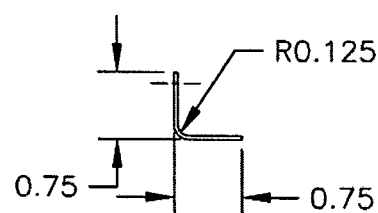


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DATE 04.01.27		TITLE DOUBLER	SCALE 1:2

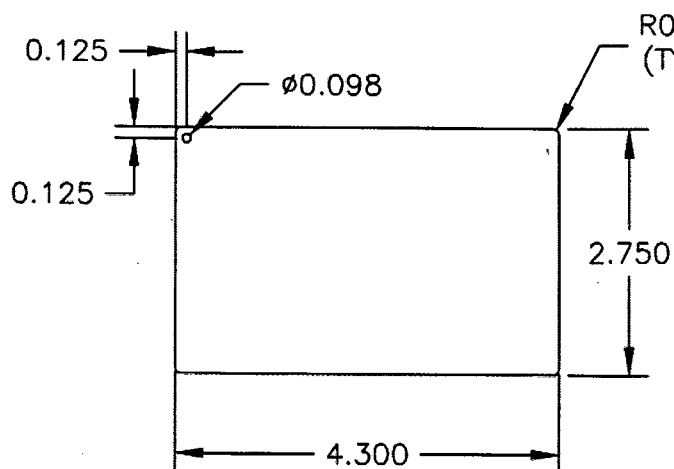
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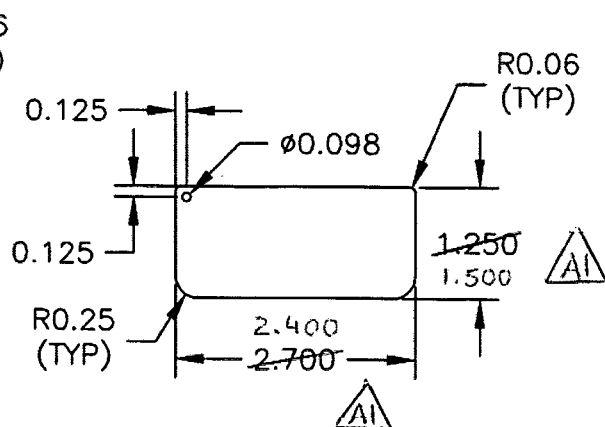
2 D3208-5 MOUNT ANGLE
FLAT PATTERN



D3208-5 MOUNT ANGLE
BEND DETAIL



2 D3208-7 FILLER



2 D3208-11 FILLER

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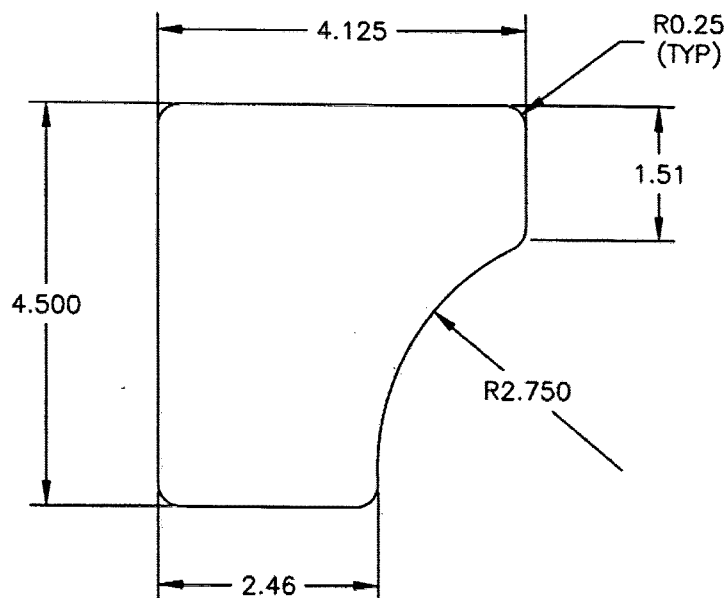
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DATE 04.01.27		TITLE DOUBLER	SCALE 1:2

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04.04.05 [Signature]



D3208-9 DOUBLER

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